Dart Aerospace Ltd. Tuesday, 04/03/2008 1:46:31 PM Date: User: Linda Lacelle **Process Sheet Drawing Name** : BRACKET : CU-DAR001 Dart Helicopters Services Customer **Job Number** : 37677 : 10710 **Estimate Number** : D32111 **Part Number** P.O. Number : 04/03/2008 S.O. No. : **Drawing Number** : D3211 REV A1 This Issue : N/A : NC **Project Number** Prsht Rev. : MACHINED PARTS : A1 First Issue : // Type **Drawing Revision** : 33117 Material **Previous Run** : 11/03/2008 Qty: Each **Due Date** Written By Checked & Approved By New Issue 05-11-17 JLM Comment : Est Rev:A Now on Waterjet 06-10-24 JLM Est Rev:B **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: M2024T3S063 2024-T3 .063 sheet 1.0 Comment: Qty: 1.4753 sf(s)/Unit Total: 8.8515 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify as D3211-1 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3211 Dwg Rev: A1 Prog Rev: A 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Form: rprocess Page 1

| Dart Ae | rospace | Ltd | | | | | | | |
|---------|---------|-------------------|----------------------|--------------------------------|----------------|--------------|--------|-------------------------------|--------------------------|
| W/O: | | 4 | W | ORK ORDER CHANG | ES | | | ·········· | |
| DATE | STEP | PROCEDURE CHANGE | | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | , | | | | |
| Part No | : | PAR #: | Fault Cat | egory: | _ NCR: Yes | No DQ | A: | _ Date: _ | |
| | | | | | QA: N | /C Close | d: | _ Date: _ | |
| NCR: | | V | VORK ORE | DER NON-CONFORMA | NCE (NCF | R) | | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verifi | cation | Approval | Approval |
| DATE | SIEP | Section A | Initial Chief Eng | - Action Description Chief Eng | Sign & Date | Sect | ion C | Chief Eng | QC Inspector |
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NOTE: Date & initial all entries

Tuesday, 04/03/2008 1:46:31 PM Dave: User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BRACKET Part Number: D32111 Job Number: 37677 Job Number: Seq. #: Description: **Machine Or Operation:** BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE Bend D3211-1 Stack as per Dwg D3211 7.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 8.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 9.0 100700 **Comment: POWDER COATING** Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 QC3 10.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 11.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O REL 12.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE 2008/3/07 Job Completion

Page 2

Form: rprocess

Dart Aerospace Ltd

| °W/O: | | WORK ORDER CHANGES | | | | | |
|-----------|--|---|----|------|-----|-------------------------------|--------------------------|
| DATE STEP | | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | Grain direction needs to be changed to 45 degrees due to bending on all | | | | B 03712 | B 08.03.05 |
| | | H sides | | | | | ` |

PAR #: NIA Fault Category: Prod FAB ASS' NCR Yes No DQA: Date: CELOS/07 Part No: D3211-1

QA: N/C Closed: 100 Date: 08 03 10

| NCR: 37677 WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|---|------|------------------------------|-----------------------------|------------------------------|----------------|--------------|-----------|-------------|
| | ' | Description of NC | Corrective Action Section B | | | Verification | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspecto |
| 28/03/05 | Ç | 3 piece broke at the bend | B | Suapa distras No replace | 08/03/05 | 0803.05 | Bogen | 08034 |
| | | | | | | | | |
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NOTE: Date & initial all entries





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| distan | DESIG | N M | DRAWN BY | | AEROS KESBURY, ONTA | PACE LTD ARIO, CANADA | - |
| 1 | CHECK | | APPROVED M | DRAWING NO, | <u></u> | | REV. A |
| | | | 4 | D3211 | * | SHEET | 1 OF 2 |
| | DATE | ····· | | TITLE | | | SCALE |
| | 03.0 | 9.03 | | BRACKET | | | 1:3 |
| | Α | | 03.09.03 | NEW' ISSUE | | | |
| | Α. | 1-10 | N 12 AT | Carrier de | Rosa DA | -011 TO 200 | 6 |

(4.3.5.7) PER DART QSI 005 4.3

FINISH: ACID ETCH AND ALODINE PER DART POWDER COAT BLACK SANDTEX (4.3 USE MINIMUM BEND RADIUS OF 0.188", EX

TOLERANCES ARE PER DART

005 4.1 0.063 THICK

MACHINE PER DRAWING FILE "D3211-A2.DWG"

TEMPLATE D3211-1T

MATERIAL: 2024-T3

CHECK PER

QSI 018 UNLESS OTHERWISE NOTED

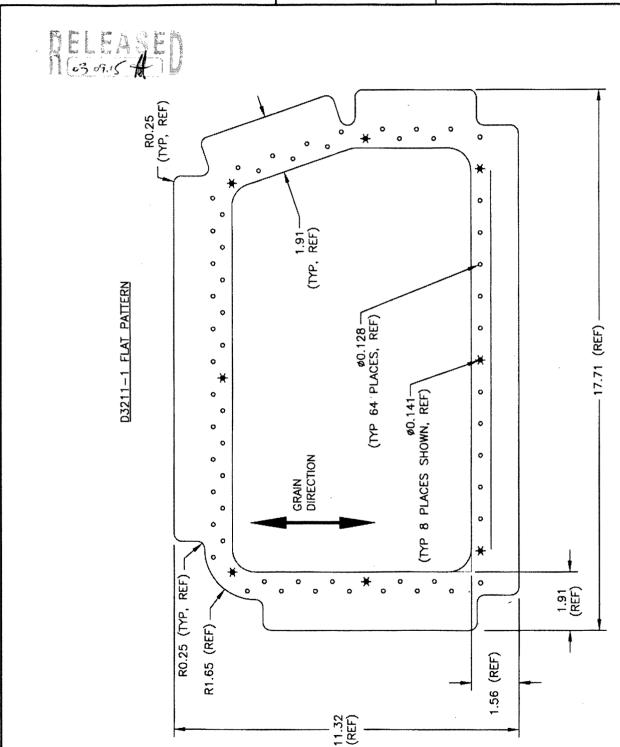
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| À | DESIGN (1) | DRAWN BY | | ROSPACE LTD y, ontario, canada |
|---|------------|----------|----------------------|-----------------------------------|
|) | CHECKED | APPROVED | DRAWING NO. D3211 | REV. A SHEET 2 OF 2 |
| | DATE | <u> </u> | TITLE | SCALE |
| | 03.09.03 | | BRACKET | 1:3 |



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| DART AEROSPACE LTD | Work Order: 37677 |
|---------------------------------|----------------------|
| Description: BRACKET | Part Number: D3211-1 |
| Inspection Dwg: 033 - Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype X Drawing Actual Method of Reject Tolerance Accept Comments Inspection Dimension Dimension 1005 - 2001 + 451 100, - 200. .144 1030 -030 050 030

| | | | | · | , |
|----------------|-------|-------------|---------|---------------------|---|
| Measured by: R | | Audited by: | 4 | Prototype Approval: | |
| Date: C | 8-3-4 | Date: | 08/03/0 | Date: | 4 |

| Rev | Date | Change | Revised by | Approved |
|-----------|------|-----------|----------------|----------|
| <u> A</u> | | New Issue | KJ/JLM | |